

**\*83768\***

Page 1

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

\*6\*

**Cust Item ID:**

\*6\*

**Customer:**

**Reference:**

**Tooling:**

**Date:**

Run Start \*NR1\*

**SPC (Y/N):**

Date:

Stop \*NR2\*

<b>Draw Nbr</b>	<b>Revision Nbr</b>
D3644	Rev A

0.00

**\*100\***

## FLOW WATER JET

0.00

## Waterjet

FLOW CNC Waterjet

## Memo

1-Cut as per Dwg D3644 Dwg Rev: A Prog Rev: A, 2-  
Deburr if necessary.

2034.050

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

## Memo

0.00

QC

## Quality Control

120

QC8- Inspect parts - second check\*

0.00

**\*120\***

## Memo

0.00

QC

## Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Page 2

## Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
relates	# MO	<del>step 1</del> change to ac 2					S relates

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Work Order ID 83768

April-25-12 10:11:18 AM

**\*83768\***

Page 3

Item ID: D3644-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Shim

Stop **\*NS2\***

Start Date: 25/04/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 09/05/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*mf*  
*12-05-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

April-25-12 10:11:22 AM

Page 1

Work Order ID: 83768

\*83768\*

Parent Item: D3644-1

\*D3644-1\*

Parent Item Name: Shim

Start Date: 25/04/2012

Required Date: 09/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			110	sf	119.2000	0.1664	1.050947			

\*M2024T3S 050\*

\*\*

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT022

119.2

117684

24.9

121216

94.3

117684

Jm/ML  
12-5-14

W/O:		WORK ORDER CHANGES					
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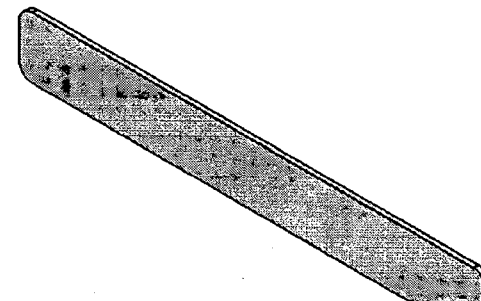
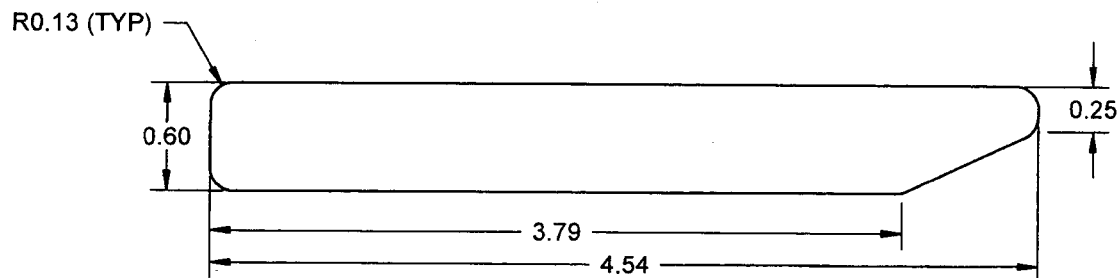
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SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83768 M/LJ  
12/04/25

**D3644-1 SHIM**  
**(REPLACES GENEVA P/N G10610-3)**

**RELEASED**  
07.09.07 #

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3644-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01lbs

A	NEW ISSUE; REPLACES G10610-3	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DTI	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	CE		
CHECKED	EB	DRAWING NO.	REV. A
MFG. APPR.	EB	<b>D3644</b>	SHEET 1 OF 1
APPROVED	NO	TITLE	SCALE
DE APPR.	SH	<b>SHIM</b>	1:1
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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